

DART AEROSPACE LTD	Work Order:	22628
Description: Frame	Part Number:	D3240-1
Dwg: D3240 Rev. B	Qty:	40
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.03.09	40
2	PG	Issue P/O: <u>2007686</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3240 Possible Supplier: GFI Material release note is required	U	05.03.09	40
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/04/06	40
4	QC6	Inspect dimensions as per Dwg D3240	U	05.04.07	40
5	GA	Deburr if necessary	2	05.04.08	40
6	ST	Identify and Stock	CL	05/04/19	40
7	AC	Cost / part <u>42.43</u>	Sgc	05.04.21	40
8	DC	Close W/O <u>42.41</u> Inspect Level 21	KJ	05.04.22	40

Rev	Date	Change	Revised By	Approved
A	04.03.08	New issue	KJ/JLM	
5b	FP	Acid Etch + Alodine per WSE 005 4.1	M/88	05/04/14 40

RELEASED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.04.14	SB	Permanent change, add Step # 5B.	<i>[Signature]</i>	05.04.07	N/A	W	<i>[Signature]</i> 05.04.25

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN IP	DRAWN BY IP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3240	REV. B SHEET 1 OF 1
DATE 05.01.06	TITLE FRAME	SCALE NTS	
A	03.12.18	NEW ISSUE	
B	05.01.06	25.50 WAS 25.19; 14.31 WAS 14.19	

RELEASED
05-02-02

D3240-1 FRAME

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
S. [Signature] [Signature]

NO. [Signature]

NO. [Signature]

R2.00 (TYP)

R1.25 (TYP)

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CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0125374 SHIPPING MEMO

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	<u>40 PCS</u>	<u>2007686</u>	<u>D3240-1</u>		<u>FRAME</u>	<u>B</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>AL 2024-T3 (QQ-A-250/4)</u>		<u>SAMUEL / KASIER ALUMINUM ATT'D</u>			<u>H/N 310277A9</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 31 MARCH 2005

G.F.I. Q.C. REP. Dart Aerospace Ltd





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ – LETTER OF COMPLIANCE

Date: 17 Mars 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058571
Customer's order #:


de commande SSMQ: 839445
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	4	.063" x 48" x 144"	2024 T3	AMS-QQ-A-250/4	310277A9

Bien à vous,
Yours truly,



Commis à l'administration.
Administration Clerk.



SHIP TO:

LES METAUX SPECIALISES SAMUEL
(SHIP TO)
21525 CLARK GRAHAM
BAIE D'URFE, PQ, CA H9X3T5

SOLD TO:

SAMUEL SON & CO LTD
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4010594

CUSTOMER PO NUMBER: N16146		CUSTOMER PART NUMBER:		SHIPPING RUN #/LOAD ID: 100080/1		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1007108	LINE ITEM: 2	SHIP DATE: 25-JUN-2004	ALLOY: 2024	CLAD: BARE	TEMPER: T3		
WEIGHT SHIPPED: 7476 LB	QUANTITY: 168 PCS EST.	B/L NUMBER: 201906	GAUGE: 0.0630 IN	WIDTH: 48.00 IN	LENGTH: 144.000 IN		

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 310277A9 Cast 168

Drop 04

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	66.9 : 68.2 (461 : 470)	44.6 : 45.8 (308 : 316)	16.3 : 17.3

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.23	4.49	0.56	1.39	0.01	0.09	0.01	0.01	0.00	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH MIL-H-6068 (AMS-H-6068). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

